



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G09132-3G-PO
Job Sheet 184021



Part No: RBW6205G09132-3G-PO **Job Qty:** 1 ea

Part Name: Trolley Adapter, Swashplate Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 11/26/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G09132-3G Rev 3 IPP Rev A outsource 18.09.18 DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		11/26/18	0.00	0.00	Purchasing		NOV 08 2018
110	Packaging	1 pcs		11/26/18	0.00	0.00	Packaging2 + 6 attachments		NOV 08 2018
120	QC	1 pcs		11/26/18	0.00	0.00	QC6		NOV 08 2018
130	Small Fab	1 pcs		11/26/18	0.00	0.50	Small Fab-4		NOV 08 2018
140	QC	1 pcs		11/26/18	0.00	0.00	QC5		NOV 16 2018
150	Packaging	1 pcs		11/26/18	0.00	0.00	Packaging3-1		NOV 16 2018
160	QC21-FG	1 Ea		11/26/18	0.00	0.00	QC21		NOV 16 2018

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 041202 MANUFACTURE RBW6205G09132-3G AS PER

Descriptions: DWG -Certificate of conformity is required

130 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into RBW6205G09132-3G. 3-Install placard using drive screws.

Oct 01, 2018 x1 [Signature]

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G09132-3GP	Trolley Adapter, Swashplate Support	1 pcs (1 ea)	100-Purchasing	5126002
91654A076	#2 Drive Screw	4 Ea (4 ea)	130-Small Fab	5015391
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	130-Small Fab	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G09132-3GP	1	0	0
130-Small Fab	91654A076	4	87	0
	RB41011	1	771	0



Container No: S126008



Part: RBW6205G09132 - 3G

Job No: 184021

Serial No/Batch: S126008

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

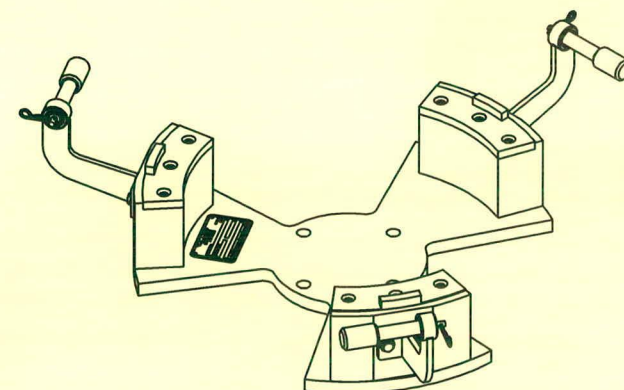
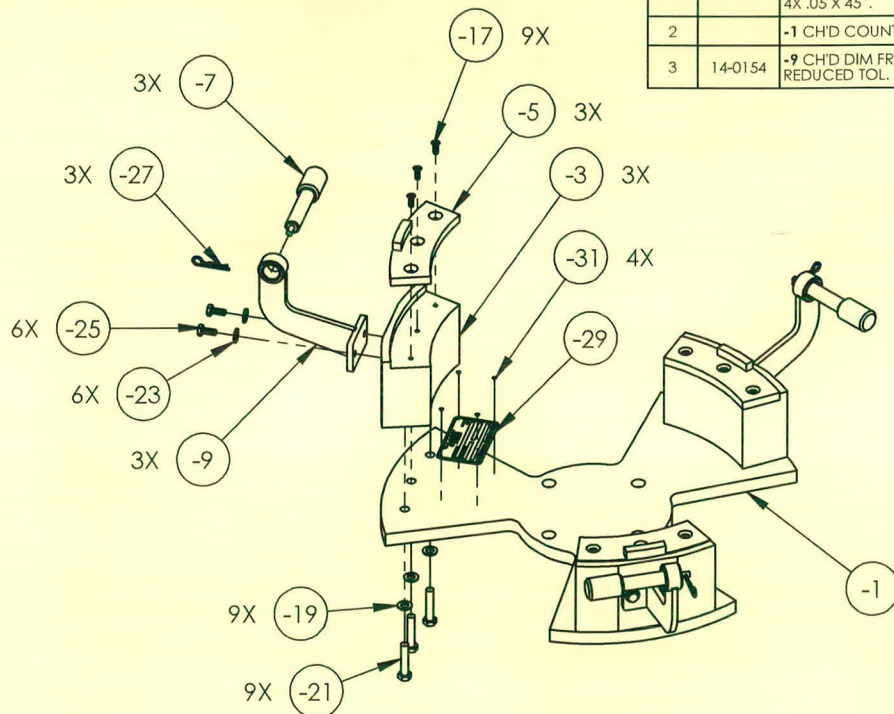
ications

d not be found.

Plex 10/1/18 2:21 PM dart.Lussier.Patrick

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-1 CH'D COUNTERBORE WAS .594 $\pm$.390 IS .594 $\pm$.39. -3 CH'D HOLE DEPTHS WAS .394 IS .39, WAS 1.000 IS 1.00, WAS .625 IS .63. -7 ADDED NOTE "CENTER OK". -13 CH'D CHAMFER WAS 4X .050 X 45° IS 4X .05 X 45°.	6/25/2013	BIM
2		-1 CH'D COUNTERBORE HOLES FROM $\varnothing$ 5.375 B.C. TO $\varnothing$ 5.512 B.C.	7/19/2013	RJC
3	14-0154	-9 CH'D DIM FROM 4.164 TO 3.92. -11 CH'D DIM FROM 4.562 TO 4.32. UPDATE TITLE BLOCK TO DART, REDUCED TOL. ON NON-CRITICAL DIMS.	9/19/2014	JAG



2,696.00 \$ us

8,954.00 \$ us

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061	5/8 X $\varnothing$ 18-3/4	2
			-3	3	BLOCK	6061	2-3/8 X 3-5/8 X 6-3/8	3
			-5	3	WEAR PLATE	WHITE NYLON	1 X 2-5/16 X 6-1/8	4
			-7	3	PIN	6061	$\varnothing$ 1 X 4-3/4	5
X			-9	3	ARM WELDMENT			6
1			-11		ARM	1018	1/4 X 4-1/4 X 4-1/2	7
1			-13		RING	1018	$\varnothing$ 1-3/16 X 7/8	8
1			-15		PLATE	1018	3/8 X 1-5/8 X 2-1/2	9
		B/O	-17	9	FLATHEAD SCREW	STEEL	M5 X .8 X 14mm MCMaster-CARR #91420A324	1
		B/O	-19	9	WASHER	STEEL	M8 MCMaster-CARR #91166A270	1
		B/O	-21	9	SCREW	STEEL	M8 X 1 X 40mm MCMaster-CARR #91180A540	1
		B/O	-23	6	WASHER	STEEL	1/4 MCMaster-CARR #90126A029	1
		B/O	-25	6	SCREW	STEEL	1/4-20 X 5/8 MCMaster-CARR #92620A539	1
		B/O	-27	3	HAIRPIN COTTER PIN	STEEL	MCMaster-CARR #98335A058	1
		B/O	-29	1	DART PLACARD	ALUMINUM	RB41011	1
		B/O	-31	4	#2 DRIVE SCREW	COATED STEEL		1
	ASSY		-9					

NOTE:
ENGRAVE -29 PLACARD WITH T/N, S/N, "MADE IN USA".

DART
AEROSPACE

TITLE
TROLLEY ADAPTER, SWASHPLATE SUPPORT

DWG NO. RBW6205G09132-3G REV 3

MATERIAL		DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX $\pm$.005	FRACTIONS $\pm$ 1/8	HEAT TREAT	
.XX $\pm$.01	ANGLES $\pm$.5°	FINISH	
.X $\pm$.1		SPEC	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AW139	
SCALE 1:8	DATE 1/19/2012	SHEET 1 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041202**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO041202
PO Date: 10/1/18
Due Date: 11/26/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	184021	RBW6205G09132-3GP			Trolley Adapter, Swashplate Support	Firmed -		11/26/18	1 Ea	0 Ea	1 Ea	\$2,698.00/Ea	\$2,698.00

Line Item Note: SIOP

Grand Total: \$2,698.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

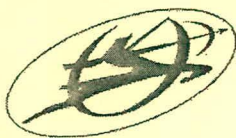
A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 10/1/18 3:09 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 308

Date: 11/7/2018
PO Ref: 041307,041202,041255
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
2 ✓	Side Plate Solenoid	4.5NR-25P ✓
1 ✓	Trolley Adapter, Swashplate Support	RBW6205G09132-3GP ✓
3 ✓	Main Rotor Mast Nut Wrench	RBA9829-AP ✓

Received by: _____

Packaged by: JS

Checked by: AM

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:041202 ✓ Dated: 11/07/2018

Our Order / Job No:041202- DAWT Order Qty:1 ✓

Part Name: TROLLY ADAPTER, SWASHPLATE SUPPORT

Part Number: RBW6205G09132-3G

Lot Size:N/A Ship Date: 11/7/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6205G09132-3G ✓ Rev:3

Material Size and Type: 6061, WHITE NYLON, 1018

Material Specifications: ASTM B221, ASTM D5989, ASTM A108 , ASTM A29,

Heat Treatment:N/A

Plating/Finish: MIL-A-8625F, TYPE II, CLASS I ZINC PLATE ASTM B633 TYPE I SC 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 11/7/18

Signed: Hernan R. Ralt

DAS
38
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
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www.atechmachineworks.com

